

Work Order ID 83500

83500

Page 1

Thursday, April 19, 2012 10:23:11 AM

Item ID: D350-589-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Side Door Latch Modification

Stop

NS2

Start Date: 4/19/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/27/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:	Process Plan:	<i>P</i>	Date: 4/20/12	Tooling:		Date:	Run Start	*NR1*
	QC:		Date:	SPC (Y/N):		Date:	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
INN-D350-589	E	

100 0.00

100 DOCUMENT CONTROL

DC Memo 0.00

Document Control Photocopy blue file and type label as per PPP D350-589-011 CHG002

JB S.7 b5/16

MLS 12-5-16

(3)

105 0.00

105 Pick Kit

Packaging Memo 0.00

Packaging

5 12/05/16 JB

(5)

110 0.00

110 QC4- 100% Inspect kits for completeness

QC Memo 0.00

Quality Control

8/21/16

(45)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

Packaging

0.00

Req'd
122

12/15/11

Packaging

Memo

0.00

Identify and pack for shipping as per QSI 014

Req'd

130

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

12/15/11

12/15/11

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 83500

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

83500
D350-589-011

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP F02.08.29Removed D2587 PlugKJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10	NAS1149D0363J	Purchased	No			105	Each	0.0000	3	15			

AN960JD10

Washer
D2237

D2237

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
			ST006	46	
			66139	1	
			82062	45	

D2583

D2583

Latch Bracket

D2585

D2585

Mounting Channel

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
			ST006	46	
			66139	1	
			82062	45	

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
			ST011	33	
			82070	33	

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
			ST011	33	
			82070	33	

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
			ST011	29	
			73297	2	
			78805	27	

12X78805

W/O:		WORK ORDER CHANGES						
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D350-589-011

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 5.00

Required Qty: 5.00

D2586

Manufactured No 105 Each 68.0000

3 15

**

D2586

Door Latch

JB

Location	Loc Qty	Loc Code
ST203A	68	2X71697
77697	18	13X78833
78833	50	

D2587

Manufactured No 105 Each 37.0000

0 5

**

D2587

Door Slug, 350 Hinge

JB

Location	Loc Qty	Loc Code
ST011	37	
74522	1	
78893	36	78893

D2589

Manufactured No 105 Each 5.0000

0 5

**

D2589

Keys, Key Chain, 350 Hinge

JB

MS20470AD4-5

Purchased No 105 Each 2,083.0000

6 30

**

MS20470AD4-5

Rivet, Universal Head

JB 12/05/16

Location	Loc Qty	Loc Code
ST011	5	
58194	5	58194
ST319	2083	
118405	732	
120142	1351	120142

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Parent Item Name: Side Door Latch Modification

83500
D350-589-011

Start Date: 4/19/2012

Start Qty: 5.00

3 15
**

Required Date: 4/27/2012

Required Qty: 5.00

MS21042L3

Purchased No 105 Each 2,849.000

MS21042L3

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	2849	
117441	16	
117885	32	
118451	5	
118927	3	
119017	1635	
119075	158	
121349	1000	

MS27039-1-15

Purchased No 105 Each 89.0000

MS27039-1-15

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST291	89	
118093	12	
118574	2	
119736	25	
121243	50	

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NOTE: Date & initial all entries

REFERENCE ONLY

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
/ 3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
/ 3				D2583	Latch Bracket
/ 3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
/ 1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
2**	2**	2**	2**	D2992-1	Doubler
1	1	1	1	D3085-041	Prop Assembly
1*	1*	1*	1*	D3015-3	Locknut
1*	1*	1*	1*	D3081-1	Prop Hinge
1*	1*	1*	1*	D3082-1	Clip
1*	1*	1*	1*	D3084-1	Prop Arm
1*	1*	1*	1*	AN4-5A	Bolt
3*	3*	3*	3*	AN960JD10	Washer
3*	3*	3*	3*	AN960JD10L	Washer
2*	2*	2*	2*	AN960JD416	Washer
1*	1*	1*	1*	AN960JD516L	Washer
3*	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
1*	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
3*	3*	3*	3*	MS27039-1-13	Screw
1*	1*	1*	1*	SL69-BS	Ball Stud
6	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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52-00-00